

Date: Wednesday, 12/13/2006 2:41:34 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 29922C		Part Number	: D2322		
Estimate Number	: 10354		Drawing Number	: D2322 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/13/2006 S.O. No. : N/A		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/5/2007 Qty: 20 Um: Each		
Previous Run	: 28791C					
Written By						
Checked & Approved By						
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet  
Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <del>H101122</del> M103038		
2.0	WATER JET	FLOW WATER JET  
Comment: FLOW WATER JET 1-Cut.as per Dwg D2322 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>  2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK   J 07-01-02
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE  
Comment: NC BRAKE Form as per Dwg D2322		

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr
						Approval QC Inspector

Part No: 12322 PAR #: N/A Fault Category: Tool/Fix AS5 NCR: Yes/No DQA: S Date: 07/02/21  
 QA: N/C Closed: S Date: 07/02/21

NCR: <u>2992</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/28	20	.032 mat'l was used by Human error. Supposed to be .040. Parts scrap.	<u>QSI042</u>	Scrap all replace parts Ensure to measure the mat'l thickness before using.	<u>SAM</u> <u>06/12/28</u>	<u>07070707</u>	<u>QSI042</u>	<u>J</u> <u>06/12/28</u>

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*QC5 07-02-19 20*

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*HS 1 am 07-02-19 20*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP Box 62/19 20 6d*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/02/21 20*

Job Completion



*u 07-02-21*

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29922C
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>SAY</i>	Audited by:		Prototype Approval:	N/A
Date:	<i>06/13/28</i>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM <del>✓</del>	SJL <del>✓</del>

**DART**

DESIGN REV	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JW</i>	DRAWING NO. D2322
DATE 98.09.29	STEP SPACER	SHEET 1 OF 1
A	94.10.14	SCALE 1:2
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001

**RELEASED**  
18.10.88 DS**UNDER REVIEW**

01.07.15 SP

~~DESIGNED BY BUT CHECKED WITH  
DTS BEFORE MANUFACTURE~~

OK 6/14/1999

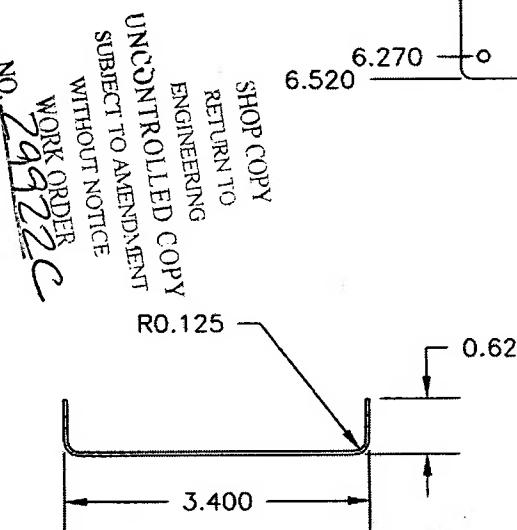
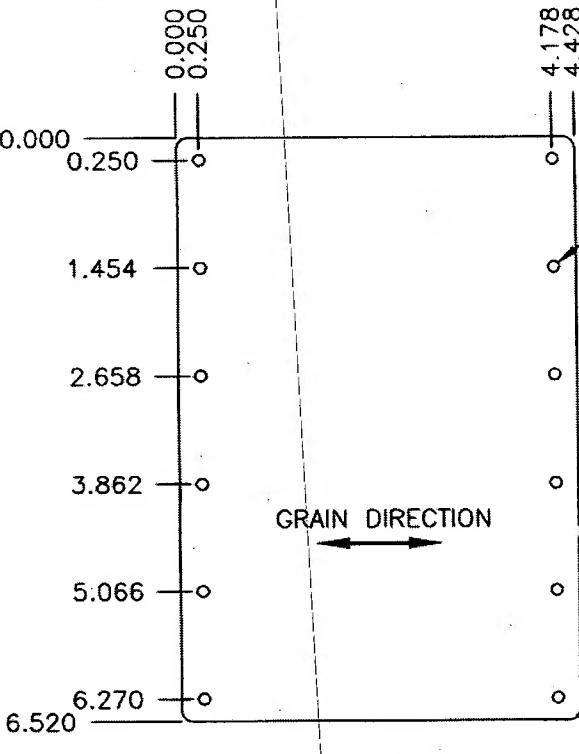
Ø0.128 (TYP 12 PLACES)

Ø0.125  
(TYP 4 PLACES)

KE99.05.06

GRAIN DIRECTION

FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICEWORK ORDER  
NO. 2992CSHOP COPY  
RETURN TO  
ENGINEERING

DART AEROSPACE LTD		Work Order:	29922 C
Description:		Part Number:	D2322
Inspection Dwg:	Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **x First Article      x Prototype**

Measured by:	<i>JAD</i>	Audited by:	<i>J</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>06-11-02</i>	Date:	<i>07-01-02</i>	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	